

Date: Thursday, 3/13/2008 10:19:54 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLUG	
Job Number	: 37926		Part Number	: D25941	
Estimate Number	: 10178		Drawing Number	: D2594 REV C	
P.O. Number	:		Project Number	: N/A	
This Issue	: 3/13/2008	S.O. No. :	Drawing Revision	: C	
Prsh Rev.	: NC		Material	:	
First Issue	: / /	Type : MACHINED PARTS	Due Date	: 4/15/2008 Qty: 500 Um: Each	
Previous Run	: 37419				
Written By	:				
Checked & Approved By	:				
Comment	: Est D 02.08.22 Make in Cobra KJ est E 06.12.11 ecn 836 EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0625	6061-T6 Round Bar .625"
		Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s) Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625) Batch <u>M106634</u> J.F. 08/03/23
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		Comment: HARDINGE CNC LATHE SMALL 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max. J.F./SG 08-03-17
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.F./SG 08-03-17
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1
		J.F. 08-03-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	POWDER COATING	POWDER COATING  <i>m 107005</i> <i>BR 08-03-27</i> <i>58</i>
Comment: POWDER COATING Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)		
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  <i>m-f</i> <i>08/03/28</i> <i>S18A</i>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
8.0	PACKAGING 1	PACKAGING RESOURCE #1  <i>m-f</i> <i>08/03/28</i> <i>S18X</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>F-P 1</i> <i>m-f</i> <i>08/03/28</i>		
9.0	QC21	FINAL INSPECTION/W/O RELEASE  <i>m-f</i> <i>08/04/03</i> <i>mf</i> <i>08-03-28</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		 <i>w</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37926
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>SC</u>	Audited by: <u>gmk</u>	Prototype Approval: N/A
Date: 08-03-17	Date: 08/03/17	Date:

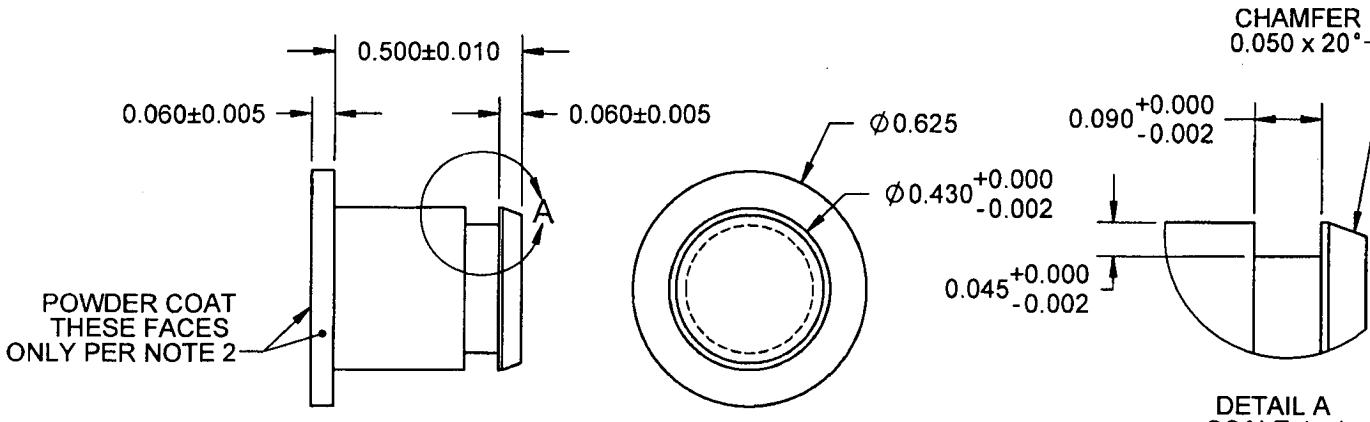
Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.12.20	Dwg Rev. updated	KJ/JLM	<i>[Signature]</i>

**DART**

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>LE</i>	APPROVED <i>CH</i>	DRAWING NO. <b>D2594</b>
DATE <b>06.11.20</b>	TITLE <b>PLUG</b>	SCALE REV. C SHEET 1 OF 1 2:1

PLUG ASSEMBLY  
06.11.28 *CH*

REV	DATE	DESCRIPTION
A	96.09.16	NEW ISSUE
B	97.03.15	ADD GROOVE AND O-RING
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE

**D2594-1 PLUG****D2594-1 PLUG NOTES:**

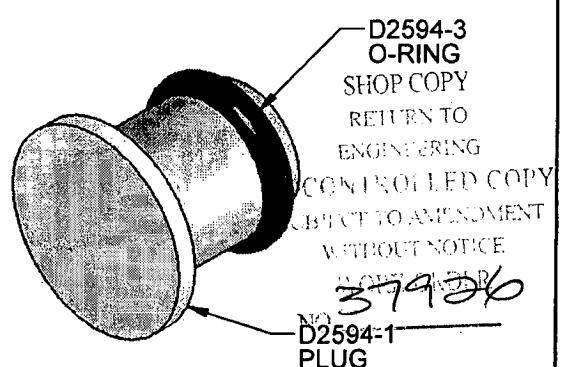
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

**D2594-3 O-RING NOTES:**

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

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